

RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Taiwanese Currency

T. T. Ensign
UNITED STATES GOVERNMENT

TO : Dr. Alan J. Goldman, Asst. Director for Technology
George G. Ambrose, Asst. Director for Production DATE: January 10, 1974

FROM : H. Frost, Jr., Assayer (Quality Control)

SUBJECT: Strip Width for Taiwan Dollars from Anaconda American Brass Company

In order to avoid large scrap losses, we are building a new die set for blanking. It will make a 70%+ recovery.

Anaconda has been sending us 11.4375 strip (11-7/16"). We went to this from 11-15/16" so that Anaconda could cut two strips from a 24" plate, edge damage prevented cutting two 11-15/16" strips. However, we find that in order to obtain eleven blanks from a die set, we would have to go to 11.5625" (11-9/16"). This would be agreeable with Anaconda, but they are not certain they could cut two strips this wide. Further investigation shows that we could pull one punch and use 10.6785" (10-11/16") and still maintain our 70%+ recovery.

Anaconda, through Mr. George E. Doremus, has stated that they would watch the strip and cut 11-9/16" when possible. If not possible, they would cut to 10-11/16". They would ship these as carload lots, each lot being composed of only one size. This would avoid having us lose time in die changes.

We will have the die set ready in about two weeks, i.e., January 21st. The next large batch from Anaconda's melting will be about the same time; at which time, they would start cutting 11-9/16", if possible, 10-11/16", if necessary. They would need some confirmation from you (The Bureau). We have made no commitments. We have no special desire to accommodate Anaconda. However, such an arrangement would speed up delivery and help us catch up on this troublesome order. Even the narrower strip would slow our blanking down very little.

H. Frost, Jr.
H. Frost, Jr.
Assayer (Quality Control)

cc: Superintendent
Deputy Superintendent
Assay
B & M
Coining ✓

1-21-74 Using (11 9/16) on 11 7/16 strip

Taiwan #1

ANACONDA

T# .054-.057

Dia .979 $\pm$.003

WT 92.5 grs.

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Coining, Cash, Assay and
Mechanical Divisions

DATE: July 26, 1973

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Taiwan Dollars

Material Handling:

<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
7800	7861-3	Dollar Strip
	7861-4	Dollar Scrap

Process Weighing:

8100	8161	Dollar
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✓ Blanking:

8200	8261	Dollar
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Annealing:

8300	8361	Dollar
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Upsetting:

8500	8561	Dollar
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Selecting:

8800	8861-2	Dollar Blanks
	8861-3	Dollar Blanks COIN

Stamping:

8600	8661	Dollar
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Counting:

8700	8761	Dollar
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Stores Items:

8700	8761	Bags
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Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

Town, John + Gene

Check Thickness of Taiwan

.055 to .058 thickness

89.5 to 95.68 grams weight 92.5 gram - 3 gr.

anything over or under set aside
to be returned to supplier

RECEIVED

Boston

MAY 14 1953

DATE: May 14, 1953

U. S. AIR FORCE

Re: Strip Specifications, 100,000,000

Approved for purchase of strip for
100,000,000 (24.1) cost.

Specified diameter: 0.979 - 1.000
0.979 - 1.000 for 0.979, and 1.000 - 1.003
0.979. Diameter: 1.000 inch dia, 1.002 inch dia.

If you desire participate in this with these cut
strip, please contact by May 25.

a

✓ J. J. Heller (via H. Theadore)
✓ J. N. (via E. Brockmough)
✓ J. Laurent, H. Frost (via Mrs. S. Higby)

100,000,000 Pieces

Purchase strip #1 New Taiwan
after settlement

Diameter .979 - .000
+ .003

Thickness of blank .054 - .057

Specification for Taiwan Coin Strip

Surface

The surface is to be clean and smooth. It is to be free of delaminations, tarnish, or rolled-in or baked-on oxide, dirt, or oils. A light film of residual sulfur-free rolling oil is permissible.

1NT

Thickness: 0.0540 +/-0.0015 inch

Chemistry: 55.0 +/-1.5% copper
18.0 +/-1.0% nickel
0.02% max lead, 0.01% max iron,
balance none.

Hardness : 80-92 RL5T

5NT

Thickness: 0.0650 +/-0.0015 inch

Chemistry: 25.0 +/-1.0% nickel, 0.6% max manganese,
0.4% max zinc, 0.02% max lead,
balance copper.

Hardness : 80-92 RL5T

Annealability

Samples (3/4 x 6") from each coil will be placed into a 1340°F furnace whose atmosphere is 10% hydrogen, 90% nitrogen. After 10 minutes in the furnace and air cooling, appearance of any blisters exceeding 0.100 inch constitutes failure of the coil. Annealed sample shall be bent 180° and straightened. Cracking at the bend constitutes failure of the coil.

UNITED STATES GOVERNMENT

Memorandum RECEIVED

Rolling & Cutting

TO : Alan J. Goldman
George G. Ambrose

JUN 21 1973

DATE: June 18, 1973

FROM : George E. Hunter *GEH*

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

SUBJECT: Taiwan Trials

*Standard .0565 thickness
standard .93.23 weight*

1962, 1963 NT \$

Blanks:

Composition : 55 Cu - 27 Zn - 18 Ni
Gauge : 0.0565 +/-0.0015 inch *.055 to .058*
Cut diameter : 0.980 + 0.002/-0.000 inch
Hardness : 72 - 77 R15T
Grain size : .030 - .060 mm
Annealing : 650 - 720°C (1202 - 1328°F) for 15 minutes
Upset diameter : 0.9616 inch
Upset groove : U.S. 25¢ configuration
Weight : 5.8 - 6.2 g (actual: 6.041 g when blanked
at 0.9812 diameter, 0.0575 ga)
Density : 8.6 - 8.7 g/cm³ (measured: 8.642 strip,
8.695 coin)

*89.5 grams
th
95.68 grams*

Dies:

Shank : 0.9655 inch obverse and reverse
Collar : 0.9800 inch, 120 reeds 0.006 inch

Coins:

Force : 81 - 84 tons - complete fill, sl. rounded
outer edge, good appearance
Diameter : 0.9859 (0.9841 - 0.9868 inch reqd.)
Edge : 0.669 (0.064 - 0.072 inch allowed)

1962, 1963 NT 5¢

Blanks:

Composition : 75 Cu - 25 Ni
Gauge : 0.0635 +/-0.0015 inch (0.0645 used)
Cut diameter : 1.139 inch
Hardness : 65 - 70 R15T
Annealing : Like U.S. 5¢
Upset diameter : 1.123 inch
Upset groove : Special #1 (drawings to be sent later)
Upset edge : 0.072 inch
Weight : 9.2 - 9.8 g (9.466 used)



Dies:

Die shank : 1.120 inch
Collar : 1.1361 inch

Coins:

Force : 101 - 107 tons - complete fill, good surface
appearance, edge not to rounded but chamfered
Diameter : 1.1430 (1.142 - 1.144 reqd.)
Edge : 0.074 + 0.005/-0.003 inch

cc: H.F. Johnson, M.W. Shreeve
S. Rosenbaum, F. Breen, J.H. Keller
✓ H. Lawrence, H. Frost

Notes on Taiwanese Currency

AC/D FR-5
FY92
95
FBI/DOJ
FBI/DOJ
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